

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 156386***156386***

Page 2

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Item ID: D412-705-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Intake Plenum Access Panel

Start Date: 1/23/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/27/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-705-013
Location : FG027DAS
27
9-89

140

0.00

140

QC

QC21- Final Inspection - Work Order Release

Memo

0.02

Quality Control

MAR 07 2017

DAS
21
9-89

MAR 07 2017

DAS
21
9-89

MAR 07 2017

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							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

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Page 1
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Work Order ID: 156386

156386

Parent Item: D412-705-013

D412-705-013

Parent Item Name: Intake Plenum Access Panel

Start Date: 1/23/2017

Required Date: 1/27/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-09 JLM Verified By:EC
IPP Rev:B ECN 1052 07-11-05 DD Verified by:EC IPP
Rev:C ECN 12-670 12.11.07 DD Verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3245-041 *D3245-041* Access Panel Assembly LH		Manufactured	No			110	Each	5.0000	1	1	DAS 6 9-89	MAR 06 2017	DAS 28 9-89
**													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST487			5						
				147936			1						
				148684			2						
				150307			2						
D3245-042 *D3245-042* Access Panel Assembly RH		Manufactured	No			110	Each	3.0000	1	1	DAS 6 9-89	MAR 06 2017	DAS 28 9-89
**													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST488			3						
				147967			1						
				151494			2						
D3245-043 *D3245-043* Door Assembly		Manufactured	No			110	Each	8.0000	2	2	DAS 6 9-89	MAR 06 2017	DAS 28 9-89
**													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST488			8						
				146686			2						
				150150			4						
				150912			2						

DQA: _____ Date: _____



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OTHER : _____					

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Work Order ID: 156386

156386

Parent Item: D412-705-013

D412-705-013

Parent Item Name: Intake Plenum Access Panel

Start Date: 1/23/2017

Required Date: 1/27/2017

Start Qty: 1.00

Required Qty: 1.00

D3245-11

Manufactured No

110 Each

5.0000

2 2

D3245-11

Gasket 9.01

**

1x B156234

DAS 28 9-89
6 MAR 06 2017

DAS 27 9-89

Location

Loc Qty

Loc Code

ST028

5

148273

5

D3245-13

Manufactured No

110 Each

5.0000

2 2

D3245-13

Gasket 9.50

**

1x B156169

DAS 28 9-89
6 MAR 06 2017

DAS 27 9-89

Location

Loc Qty

Loc Code

ST028

5

148231

5

D3245-9

Manufactured No

110 Each

5.0000

2 2

D3245-9

Gasket 8.35

**

DAS 28 9-89
6 MAR 06 2017

DAS 27 9-89

Location

Loc Qty

Loc Code

ST027

5

103050

1

150440

4

MS20427M3-3

Purchased No

110 Each

520.0000

16 16

MS20427M3-3

Rivet

**

136741

DAS 28 9-89
6 MAR 06 2017

DAS 27 9-89

Location

Loc Qty

Loc Code

GA

183

m134738

183

ST311

337

m133577

37

m134738

300

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Shop Packet Print

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				Lead hand / Supervisor Approval Verification							
				QC / QA Coordinator Approval							
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OTHER : _____											

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Work Order ID: 156386

156386

Parent Item: D412-705-013

D412-705-013

Parent Item Name: Intake Plenum Access Panel

Start Date: 1/23/2017

Required Date: 1/27/2017

Start Qty: 1.00

Required Qty: 1.00

MS21060-L3K

Purchased

No

110

Each

153.0000

8

8

MS21060-L3K

Nut Plate

DAS
28
9-89
MAR 06 2017
DAS
6
9-89

Location

Loc Qty

Loc Code

GA

27

m135297

27

ST300

126

m135948

76

m136182

25

m136579

25

WAS
7

DAS
27
9-89

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-1	ACCESS PANEL
		1					D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C3A	BOLT
		3					AN3C4A	BOLT
						30	AN960JD10	WASHER
	16	44	36		12		MS20427M3-3	* RIVET
						4	MS21051-L3K	NUT PLATE
	8	22	18		6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		MS9321-09	WASHER

* Acceptable to substitute for MS20615M3-3 rivets. At installation, it is acceptable to use longer rivets if required.